

Work Order ID 65202

Monday, January 10, 2011 7:51:36 AM



Page 1

Item ID: D4030-043
Revision ID:
Item Name: Long Basket Assembly, Light Lid (350)
Start Date: 1/10/2011 Start Qty: 1.00
Required Date: 1/18/2011 Req'd Qty: 1.00
Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals: Process Plan: MF Date: 11-01-10 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4030	C								
100	Pick Kit	0.00							
Packaging	Memo	0.00							
Packaging									
110	Assemble as per dwg	0.00							
HandFinish	Memo	0.00							
Hand Finishing									
120	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

u.l./kufEPH/01/17 (U)Selovics

(K)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 65202

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Item ID: D4030-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Long Basket Assembly, Light Lid (350)

Start Date: 1/10/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 1/18/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

PPA65202

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

mf
10-11-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

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Page 1

Work Order ID: 65202

Parent Item: D4030-043

Parent Item Name: Long Basket Assembly, Light Lid (350)





Start Date: 1/10/2011

Required Date: 1/18/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.23 verified by:EC IPP Rev:B as
per dwg revB DD 10.04.20 verified by:EC IPP Rev:C added
NAS1149F0332P & NAS1149C0432R 10.06.16 DD
VERF:EC IPP Rev:D as per
dwg revC DD 10.08.18 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2530  Handle Weldment		Manufactured	No			100	Each	7.0000	1	1		1/11/14/8	
<div> <div>Location</div> <div>ST506</div> <div>64443</div> </div> <div> <div>Loc Qty</div> <div>7</div> <div>7</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
D2535  Spring		Manufactured	No			100	Each	62.0000	2	2		1/11/14/8	
<div> <div>Location</div> <div>ST504</div> <div>58331</div> <div>64280</div> </div> <div> <div>Loc Qty</div> <div>62</div> <div>22</div> <div>40</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> </div>													
D2537  Bushing		Manufactured	No			100	Each	34.0000	2	2		1/11/14/8	
<div> <div>Location</div> <div>ST504</div> <div>62393</div> <div>64064</div> </div> <div> <div>Loc Qty</div> <div>34</div> <div>4</div> <div>30</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> </div>													
D3913-041  Long Basket Base Assembly, 350		Manufactured	No			100	Each	0.0000	1	1		1/5/11/17	

B6503 (1x)

W/O:		WORK ORDER CHANGES					
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Page 2

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Parent Item: D4030-043

Parent Item Name: Long Basket Assembly, Light Lid (350)

Start Date: 1/10/2011

Required Date: 1/18/2011

Start Qty: 1.00

Required Qty: 1.00

D3915-041 Manufactured No

100 Each 0.0000

1

1



Light Lid Assembly, Long Basket

B65204 (12)



1/11/17

D3917-3 Manufactured No

100 Each 30.0000

6



Washer



1/11/14

Location

Loc Qty

Loc Code

ST095

29

64589

29

ST096

1

57144

1

100

Each

1.0000

2

D3953-3

Manufactured No



Gas Spring Stud, Lid



1/11/18

Location

Loc Qty

Loc Code

ST100

1

64020

1

100

Each

1.0000

2

D3953-7

Manufactured No



Spring Spacer



1/11/14

Location

Loc Qty

Loc Code

ST101

1

63674

1

100

Each

13.0000

2

D3953-9

Manufactured No



Gas Spring Washer



1/11/14

Location

Loc Qty

Loc Code

ST100

11

64450

11

ST103

2

60008

2

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item Name: Long Basket Assembly, Light Lid (350)


Start Date: 1/10/2011

Required Date: 1/18/2011

Start Qty: 1.00


Required Qty: 1.00


D3953-17 Manufactured No 100 Each 5.0000 2  2/1/14 SP

 Gas Spring Spacer

Location Loc Qty Loc Code


ST101 5
57143 1
64021 4


D3953-19 Manufactured No 100 Each 22.0000 1  2/1/14 SP

 Gas Spring Bracket

Location Loc Qty Loc Code


ST 3
59213 3
ST097 19
64810 19


D3953-21 Manufactured No 100 Each 11.0000 1  2/1/14 SP

 Gas Spring Bracket

Location Loc Qty Loc Code

ENG 5
56407 5
ST102 6
57145 2
59214 4

D3969-3 Manufactured No 100 Each 20.0000 1  2/1/14 SP

 Spring (Basket Lid)

Location Loc Qty Loc Code

ST272 20
64285 20

W/O:		WORK ORDER CHANGES					
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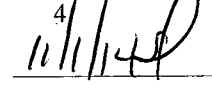

Parent Item Name: Long Basket Assembly, Light Lid (350)

Start Date: 1/10/2011


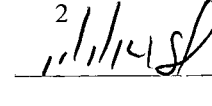

Required Date: 1/18/2011

Start Qty: 1.00


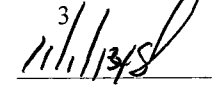

Required Qty: 1.00

AN3-14A Purchased No 100 Each 72.0000 4  4/11/14 

 Bolt


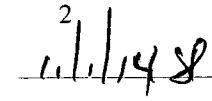

Location	Loc Qty	Loc Code
ST351	72	
114941	22	
115108	50	

AN3-20A Purchased No 100 Each 62.0000 2  2/11/14 

 Bolt

Location	Loc Qty	Loc Code
ST352	62	
105125	22	
115371	40	

AN4-12 Purchased No 100 Each 32.0000 3  3/11/14 

 Bolt

Location	Loc Qty	Loc Code
ST357	32	
114784	7	
116419	25	

AN5-17A Purchased No 100 Each 58.0000 2  2/11/14 

 Bolt

Location	Loc Qty	Loc Code
ST339	58	
115504	8	
116003	50	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item: D4030-043



Parent Item Name: Long Basket Assembly, Light Lid (350)

Start Date: 1/10/2011

Required Date: 1/18/2011

Start Qty: 1.00

Required Qty: 1.00

AN5-21A	Purchased	No	100	Each	50.0000	2	2. <i>11/11/11</i>
Bolt							

			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>		
			ST339	50			
			114714	50			
AN310-4	Purchased	No		100	Each	33.0000	3
NUT							

			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>		
			ST324	33			
			116075	33			
AN310C4	Purchased	No		100	Each	16.0000	2
Nut							

			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>		
			ST349	16			
			114306	16			
MS21042L3	Purchased	No		100	Each	3,282.000	6
Nut							

			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>		
			ST300	3282			
			114784	9			
			115835	773			
			116391	900			
			116540	800			
			116549	800			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 65202



Parent Item: D4030-043



Parent Item Name: Long Basket Assembly, Light Lid (350)

Start Date: 1/10/2011

Required Date: 1/18/2011

Start Qty: 1.00

Required Qty: 1.00

MS21042L5 Purchased No 100 Each 1,369.000 4 4/1/14
 Nut

Location	Loc Qty	Loc Code
ST139	26	
114813	26	
ST300	1343	
115156	5	
115594	500	
116104	142	4
116105	496	
116548	200	

MS24665-151 Purchased No 100 Each 574.0000 3 3/1/14
 Cotter Pin

Location	Loc Qty	Loc Code
ST309	574	
17566	574	3

MS24665-300 Purchased No 100 Each 32.0000 2 2/1/14
 Cotter Pin

Location	Loc Qty	Loc Code
ST309	32	
110123	32	2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 65202

Parent Item: D4030-043

Parent Item Name: Long Basket Assembly, Light Lid (350)

Start Date: 1/10/2011

Required Date: 1/18/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0432P

Purchased

No

100

Each

238.0000

6



Washer



6
1/11/148

Location

Loc Qty

Loc Code

ST275

238

112940

92

114405

1

114576

4

114718

2

116169

1

116391

138

2
4

NAS1149F0563P

Purchased

No

100

Each

158.0000

4



Washer



4
2/1/148

Location

Loc Qty

Loc Code

ST298

158

114576

158

4

NAS1149F0332P

Purchased

No

100

Each

318.0000

8



WASHER



8
1/11/148

Location

Loc Qty

Loc Code

ST275

318

18057

318

8

NAS1149C0432R

Purchased

No

100

Each

208.0000

2



Washer



2
1/11/148

Location

Loc Qty

Loc Code

ST297

208

114292

50

114742

67

116304

91

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

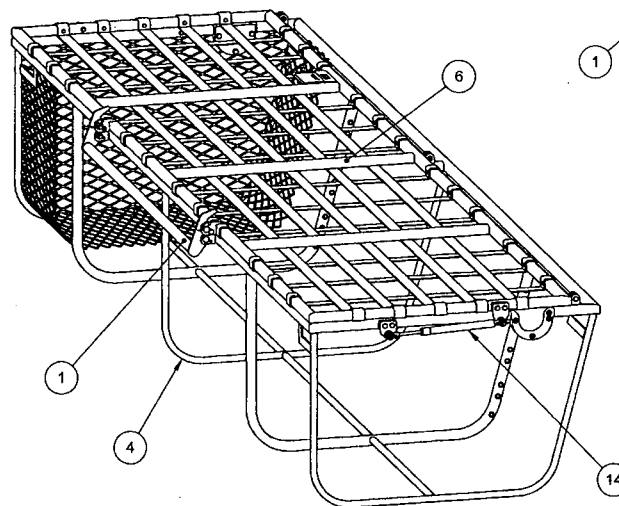
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

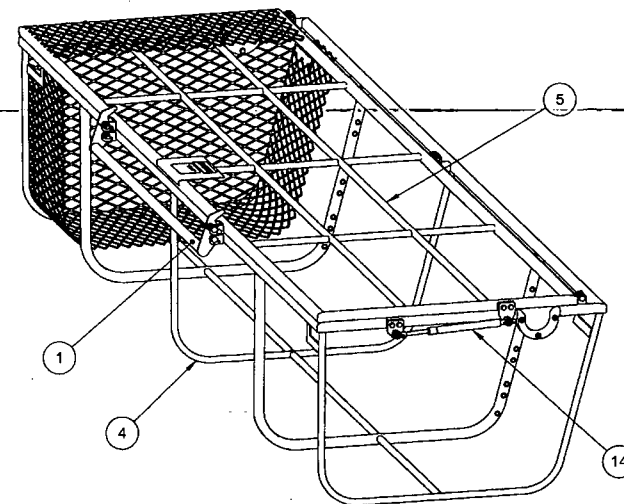
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NOTE: Date & initial all entries

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4030-041	LONG BASKET ASSY (350)
		X	D4030-043	LONG BASKET ASSY, LIGHT LID (350)
1	1	1	D2530	HANDLE WELDMENT
2	2	2	D2535	SPRING
3	2	2	D2537	BUSHING
4	1	1	D3913-041	LONG BASKET BASE ASSY (350)
5	1		D3914-041	LONG BASKET LID ASSY (350)
6		1	D3915-041	LIGHT LID ASSY-LONG BASKET
7	6	6	D3917-3	WASHER
8	2	2	D3953-3	GAS SPRING STUD, LID
9	2	2	D3953-7	GAS SPRING SPACER
10	2	2	D3953-9	GAS SPRING WASHER
11	2	2	D3953-17	GAS SPRING SPACER
12	1	1	D3953-19	GAS SPRING BRACKET
13	1	1	D3953-21	GAS SPRING BRACKET
14	1	1	D3969-3	SPRING
15	4	4	AN3-14A	BOLT
16	2		AN3-16A	BOLT
17		2	AN3-20A	BOLT
18	3	3	AN4-12	BOLT (DRILLED)
19	4	2	AN5-17A	BOLT
20		2	AN5-21A	BOLT
21	3	3	AN310-4	NUT, CASTELLATED
22	2	2	AN310C4	NUT, CASTELLATED
23	6	6	MS21042L3	NUT
24	4	4	MS21042L5	NUT
25	3	3	MS24665-151	COTTER PIN
26	2	2	MS24665-300	COTTER PIN
27	6	6	NAS1149F0432P	WASHER
28	4	4	NAS1149F0563P	WASHER
30	8	8	NAS1149F0332P	WASHER
31	2	2	NAS1149C0432R	WASHER



D4030-043 LONG BASKET ASSY, LIGHT LID (350)
(MESH SHOWN LOCALLY FOR CLARITY)



D4030-041 LONG BASKET ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

#65702

RELEASED
10-08-12
ECN 10-596

NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT: -041: 72 lbs APPROX
-043: 57 lbs APPROX

C	QTY FOR ITEMS #30 & #31 UNDER -043 WERE MISSING (B8-1); QTY FOR ITEM #3 WAS 4 (D6-1), ONLY 2 ARE REQUIRED, AFFECTS SECTION C-C (D3-3).	MB	10.07.23
B	AN5-21A BOLT WAS AN5-19A: BOM & (D3-3)	JPH	10.04.06
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	ALJ		
DRAWN			
CHECKED	JFS		
MFG. APPR.	JFS		
APPROVED			
DE APPR.			
DATE	10.07.23		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4030** REV. C
SHEET 1 OF 3

TITLE **LONG BASKET ASSY (350)** SCALE NTS

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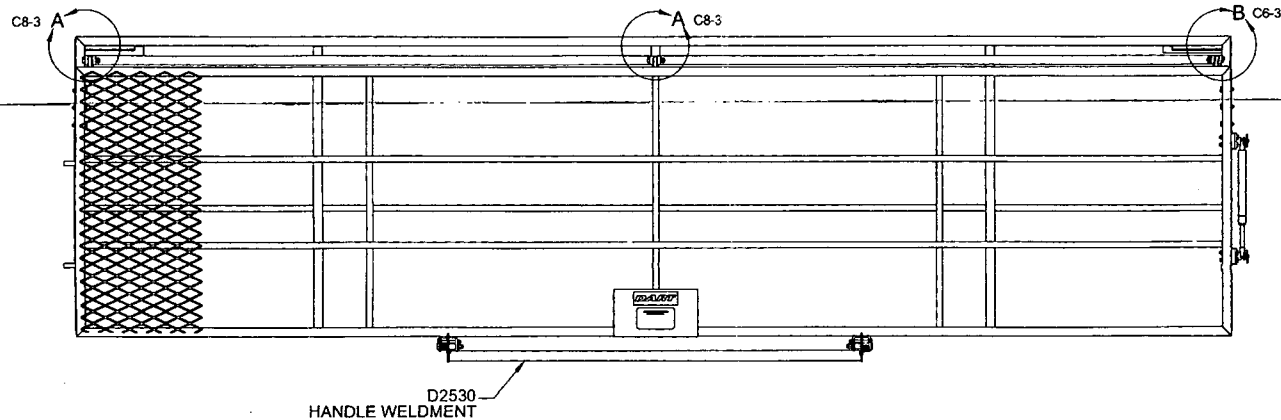
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

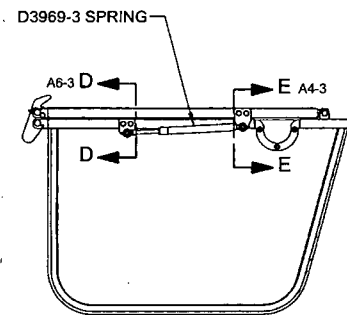
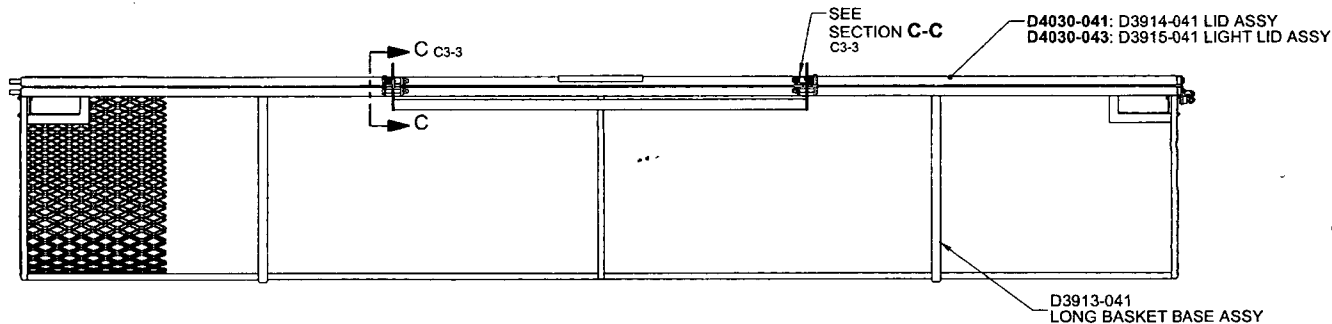
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



#65202



D4030-041 LONG BASKET ASSY (350) (SHOWN)
(MESH SHOWN LOCALLY OR REMOVED FOR CLARITY)

D4030-043 SHORT BASKET ASSY, LIGHT LID (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
10.08.17.00

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO.	REV. C
MFG. APPR.	SE2	D4030	SHEET 2 OF 3
APPROVED	DE	TITLE	SCALE
DE APPR.	TH	LONG BASKET ASSY (350) ___ NTS.	
DATE	10.07.23	<div><p><small>COPYRIGHT © 2010 BY DART AEROSPACE LTD</small></p><p><small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small></p></div>	

8 7 6 5 4 3 2 1

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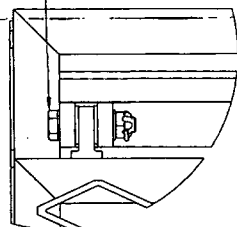
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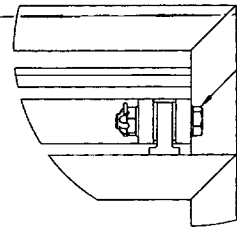
NOTE: Date & initial all entries

AN4-12 BOLT
D3917-3 WASHER, 2X
NAS1149F0432P WASHER, 2X
AN310-4 NUT, CASTELLATED
MS24665-151 COTTER PIN



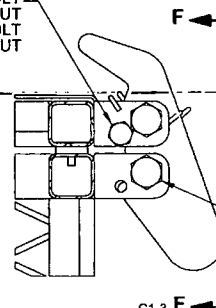
DETAIL A D8-2
D5-2

D4030-041: AN3-16A BOLT
MS21042L3 NUT
D4030-043: AN3-20A BOLT
MS21042L3 NUT



DETAIL B D3-2

AN4-12 BOLT
D3917-3 WASHER, 2X
NAS1149F0432P WASHER, 2X
AN310-4 NUT, CASTELLATED
MS24665-151 COTTER PIN

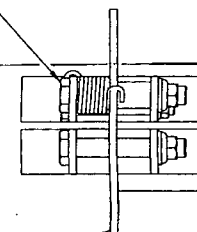


SECTION C-C B4-2
B6-2

D4030-041: AN5-17A BOLT
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT

D4030-043: AN5-21A BOLT
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT

AN5-17A BOLT
NAS1149F0563P WASHER
MS21042L5 NUT



D2530
HANDLE WELDMENT
REF

VIEW F-F C3-3

D3953-17 GAS SPRING SPACER
D3953-21 GAS SPRING BRACKET
AN3-14A BOLT
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
2 PL

D3953-3 GAS SPRING STUD, LID
D3953-7 GAS SPRING SPACER
D3953-9 GAS SPRING SPACER
NAS1149C0432R WASHER
AN310C4 NUT, CASTELLATED
MS24665-300 COTTER PIN

D3969-3 SPRING
REF

SECTION D-D B2-2

D3953-17 GAS SPRING SPACER
D3953-19 GAS SPRING BRACKET
AN3-14A BOLT
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
2 PL

D3953-3 GAS SPRING STUD, LID
D3953-7 GAS SPRING SPACER
D3953-9 GAS SPRING SPACER
NAS1149C0432R WASHER
AN310C4 NUT, CASTELLATED
MS24665-300 COTTER PIN

D3969-3 SPRING
REF

SECTION E-E B1-2

#65202

RELEASED
10.08.124

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	1	HAWKESBURY, ONTARIO, CANADA	
CHECKED	1	DRAWING NO.	REV. C
MFG. APPR.	JFS	D4030	SHEET 3 OF 3
APPROVED	1	TITLE	SCALE
DE APPR.	1	LONG BASKET-ASSY (350)	NTS
DATE	10.07.23	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries